Work Order ID 121904

Page 1

Thursday, July	03, 2014 4:0	9:59 PM			9(14						ruge 1
Item ID: Revision ID: Item Name:	D3580-5 Bracket			Accept	*N900	0040	100)* ፡	Setup Sta	17	S1* S2*
Start Date: Required Date:	7/04/14 7/04/14	Start Qty: 10.00 Req'd Qty: 10.00	*1 0 * *1 0 *		Cust Item :					·	()/
Reference: Approvals:	Process Pl	an:	Date: 4 1	Tooling:	D	ate:	_	F	Run Sta	^I <i>V</i> I	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	^p *\	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D3580	C								•		DAS
100 *1 00* Waterjet		FLOW WATER JET		0.00					_ a_		23 9-89 MO7
FLOW CNC Waterj 304.050°	et	Memo 1-Cut D358 Dwg Rev:_ Prog Rev:_ 2-Deburr if	0-1F as per Dwg C necessary	0.00	•			·			
110		QC2- Inspect parts off n	nachine FAI/FAIR	0.00							DAS
110		Мето		0.00	•			(0	0		9-89 14 O1
Quality Control				·	DAS						
120 *120*		QC8- Inspect parts - seco	ond check	0.00 <i>9B</i> 14/871	27			(12)	3 · · ·	<i>*</i> :	
QC Quality Control		Memo		0.00				(10)			-

DQA:			_ Date:										*DART	
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Vork Order u	pdate only	A EROSPĀCE	
						DISPOSITION		AGAINST D	NST DEPARTMENT/PROCESS					
Work Orde	er: _					_	. 1			-				
						Rework			Skid-tube	Crosstube	_	Water Jet	Engineering	
Part N	اο.					Scrap			Machining	Small Fab	_	od. Eng. Coor.	Quality	
						Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	۱o. <mark>.</mark>	<u> </u>				Suspected Unapproved	l		Large Fab	Composite		Supplier		
Root					Desc	ription of work order update		nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	 Verification 	QC Inspector	
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material	Ш									•				
Operator			1				İ							
Offset/Setup ,	Ш						l							
Process	Щ													
Supplier	Ш											1		
Training	Н													
Transport	H			İ										
Unapproved		L		<u> </u>	1		EAL	III T CA	TEGORY		<u> </u>		<u> </u>	
					_	General	FA	OLI CA	TEGORT					
Landi		Bending				Bend	_	leolio/I	Program	Г	Outside Dir	nensions [Pressure/Førced	
l i		•	ot Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain	rogram	<u> </u>	Over/Unde	 	Set-up	
	\vdash	Cracks	or concer	iitiic		Broken/Damage/Defect		Hardwa	are	<u> </u>	Part Incorre		Temperature/Cure	
	\vdash	4	nk/Ripple	-/Wave		Burrs	-	4	tion Incomplete/Un	agualified	Part Lost/M	<u> </u>	Weld	
	\vdash	Cuffs	y mppic	., ••a•c	\vdash	Contamination	一		tions Incomplete/U	· -	Part Moved	_	Wrong Stock Pulled	
	-	Crushing				Countersink		-	gned/off center	ŀ	Positioned		-	
	-	Heat Tre			<u> </u>	Cut Too Short		Mislab	-	-	Power Loss		Other	
		Inspection		Tube		Drawing		Misrea		L	·			
		Marks/C				Drill Holes		Off-set						
	Г	4	Sequence	•		Finish		Out of	Calibration					
		1	vist in Tul			Fit/Function		Out of	Sequence					

Work Order ID 121904 Page 2 Thursday, July 03, 2014 4:09:59 PM Accept Item ID: D3580-5 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Bracket *10* Start Date: 7/04/14 **Start Otv:** 10.00 **Cust Item ID:** Required Date: 7/04/14 Rea'd Otv: 10.00 **Customer:** Reference: Run Start Approvals: Date: Process Plan: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Oty Oty Number Stamp 130 Identify as per dwg & Stock Location 0.00 *120* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* QC 0.00 Memo Quality Control

DAS 26

9-89

DQA:			Date:			•									TDART
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AÉROSPÂCE	
Mark Ords						DISPOSITION AGAINST DEPARTME					ARTMENT	PROCESS			
Work Orde	-					Powerk	ıİ		Skid-tube	Crosstube			Water Jet	\neg	Engineering
Dowt N	10					Rework			Machining Machining	Small Fab		Pro	d. Eng. Coor.	ㅓ	Quality
Part N	٠٠					Scrap Use-as-is			noforming	Finishing	\dashv		e/Packaging	\dashv	Other
NCR N	lo.					Suspected Unapproved	H	men	Large Fab	Composite	\blacksquare	rice/stor	Supplier	ᅱ	
NCN	٠٠٠.					Suspected Onapproved	1		Large Tab	composite			adbhie. [_	
Root					Desc	ription of work order update		nitial	Act	ion		Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	,	QC Inspector
Design				-											· · · · · ·
Doc/Data															
Equip/Tooling															
Handling/Pre					1										
Material														-	
Operator															
Offset/Setup											ŀ				
Process															
Supplier						,					ı				
Training							l				Į			l	
Transport									l		ĺ				
Unapproved															
						***	FA	ULT CA	regory				·		
Landi	ng G	iear				General		1					Г	_	
		Bending				Bend		4	rogram		\vdash	Outside Dim	⊢		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			-	Over/Under		_	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa			-	Part Incorred	- t	$\overline{}$	Temperature/Cure
ļ	Ш	Crimp/Ki	nk/Ripple	/Wave		Burrs		-1 '	ion Incomplete/Ur		-	Part Lost/Mi	ssing		Weld
	-	Cuffs				Contamination		-	tions Incomplete/L	Jnclear	Н	Part Moved	Ĺ		Wrong Stock Pulled
	-	Crushing				Countersink		-1	gned/off center		ы	Positioned V		—	l
	\vdash	Heat Trea			<u> </u>	Cut Too Short		Mislab			Ш	Power Loss/	Surge]	Other
		Inspectio		Tube		Drawing		Misrea			-				
		Marks/Cl				Drill Holes		Off-set			-	N.			
	Ш		Sequence			Finish		┥	Calibration		-				
		Wave/Tw	vist in Tuk	oe -		Fit/Function	l	Out of	Sequence						

Page 1

Work Order ID: 121904

121904

Parent Item:

D3580-5

Parent Item Name: Bracket

D3580-5

Start Date: 7/04/14

Required Date: 7/04/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV:A 14.07.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No				sf	658.3700	-	.0 .094737	-	DAS	
M304S18	RGA								**	。5		23 9-89	14-07

304/316 .050 Sheet

Location	Loc Qty	Loc Code	
MAT019	646.37		
117188	3		
117766	5		
120604	5		
122325	3		
123155	3		
124572	38		
M126647	31.55		
M128254	91.57		
M128435	123.25		
M128864	65		
M129530	278		129530
MAT020	12		•
124029	2		
M126098	10		

DQA:			Date:		-	WORK ORDER NON	c	ANEO!	DNANICE / HE	DOATE			40	DARIT
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AEROSPACE
Work Orde	ır.					DISPOSITION								
Work Orde	-				_	Rework]		Skid-tube	Crosstube	7	Water Jet	ΠE	ngineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite]	Supplier		
Root		<u>-</u>			Desc	ription of work order update		Initial	Acti	ion	Sign &			
Cause		[®] Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	Date	Verification		QC Inspector
Design		:												
Doc/Data														
Equip/Tooling	_						ļ							
Handling/Pre	_						1							
Material	_													
Operator	_													
Offset/Setup	_													
Process														
Supplier												:		
Training	_													
Transport	_] .									
Unapproved			<u> </u>	<u> </u>			L_							
				· · · · · · · · · · · · · · · · · · ·			FA	ULT CA	regory					
Landir I						General	_] e . e . 7e	\	Г	Outside Dim	: Г		essure/Forced
	_	Bending			-	Bend	┝	- 1	Program	<u> </u>	-4	⊢	— (t-up
	-	Centre N	ot Concer	ntric	-	BOM/Route	\vdash	Grain		<u> </u> _	Over/Under	-		nperature/Cure
	$\overline{}$	Cracks		<i>.</i>	<u> </u>	Broken/Damage/Defect	\vdash	Hardwa			Part Incorred	 -	- Ne	
	-	Crimp/Ki	nk/Ripple	/Wave		Burrs	-	4	ion Incomplete/Un		Part Lost/Mi	ssing		ong Stock Pulled
	-	Cuffs			_	Contamination	\vdash	4	tions Incomplete/U	Inclear	Part Moved		vv	ong stock Pallea
		Crushing			<u> </u>	Countersink	\vdash	-1 '	gned/off center	-	Positioned V Power Loss/		Otl	ner.
		Heat Trea		T. d	-	Cut Too Short	\vdash	Mislabe		L	Trower ross/	onige [JULI	ici
		Inspectio	-	rupe	<u> </u>	Drawing Drill Holos	-	Misrea			-			
		Marks/Cl				Drill Holes	\vdash	Off-set						
		_	Sequence		<u> </u>	Finish	\vdash	4	Calibration					
		wave/Tw	vist in Tuk	oe		Fit/Function		Jout of	Sequence					

DART AEROSPACE LTD	Work Order:	121904
Description: Brack&	Part Number:	D3580-5
Inspection Dwg: 03580 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194"	t0005-0001	0.95"	_		V	JLmoi
0.294" 1.75" 0.75"	to010	0.753" 0.754"	_		٧.	
1.75"	H0 535	1.753"	-		V	
0.75	и	0.754"			V	
			,			
					-	
	DAS					

	23		DAS		
Measured by:	9-80	Audited by:	El 27	Preliminary Approval:	
Date:	14-07.9	Date:	14/07/09	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15

